DAPCO™ 3041FR Paste Adhesive

Description:

DAPCO™ 3041FR paste adhesive is a two–part, room temperature curing, epoxy based, 100% solids, self-extinguishing, general purpose adhesive. The material has a convenient one-to-one mix ratio by volume. The product is available in a variety of kit sizes including: 50ml, 200ml and 400ml side by side cartridges, pints, quarts, and gallons. (Contact your local representative for special packaging requests.)

For more information, contact:
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Features and benefits:

- **Semi-thixotropic flow properties**
- **100% solids content**
- **Room temperature cure**
- **Room temperature storage**
- **180°F/82°C performance**
- **Meets the FAR 25.853**
- **One-to-one mix ratio by volume**
- **Bonds to a variety of metallic and non-metallic substrates including aramid fibers, acrylic/PVC alloys, and polycarbonates such as Kelvar®, Kydex® and Lexan®**

TECHNICAL DATASHEET

Typical properties

	Part A	Part B	Mixed
Color	White	Amber	Tan
Solids, %	100	100	100
Consistency	Paste	Paste	Paste
Density, g/cc	1.15	0.99	1.1
Shelf life at 77°F	12 months	12 months	

Handling

Mixing	The two components should be mixed / dispensed just prior to use. Part A and B must be mixed in the correct ratio and mixed thoroughly.	
Mix ratio	The recommended mix ratio for DAPCO™ 3041FR is:	
		Volume
	Part A	1
	Part B	1
Pot life	(100g mass) - 90 minutes	

Application

Mixing

PLEASE NOTE: The curing reaction that takes place upon mixing of this product will generate heat. This is normal. However, it is DANGEROUS to mix quantities greater than 450 grams, as an uncontrollable exothermic reaction may occur causing the decomposition of the material and release of TOXIC FUMES.

Applying

The substrates must be free from contaminates, i.e., dirt, oil, grease, etc. Clean the surface by wiping with a suitable solvent/cleaning agent and drying thoroughly. Mechanical roughening of the surfaces or application of a primer such as BR 6750 will often improve performance. The parts to be bonded should be held in contact with the adhesive until set. Handling strength is achieved in 6 hours at 77F/ 25C (loads on the product should be limited until full cure is achieved).

Curing

Full cure is achieved in 7 days at room temperature (77°F/25°C) or one hour at room temperature followed by two hours at 180°F/82°C.

Cleanup

Before the material has cured, the excess may be removed using most standard industrial solvents, such as Acetone.

TECHNICAL DATA SHEET

Typical cured properties

When cured in accordance with the recommended schedule, the following typical properties are developed:

Hardness, shore "D"	70-80	
Shear adhesion to: Aluminum (2024 T3) clad, phosphoric acid anodized		
	@-67°F/-55°C	3900 psi (20.7 MPa)
	@77°F/25°C	3800 psi (26.2 MPa)
	@150°F/66°C	1000 psi (6.7 MPa)
	@180°F/82°C	800 psi (5.5 Mpa)
T peel strength – ASTM D1876	@77°F/25°C	22 lb_f/in (3.9 N/mm)
Drum peel strength – ASTM D1781	@77°F/25°C	32 lb_f/in (5.6 N/mm)
Compression strength	@77°F/25°C	6,200 psi (42.7MPa)
Compression modulus	@77°F/25°C	200,000 psi (1,379 MPa)
Insert pull-out strength	@ 77°F/25°C	NAS 1836-7 = 350 psi (2.4 MPa) NAS 1836-14 = 700 psi (4.8 MPa) NAS 1836-22 = 975 psi (6.7 MPa)
Tensile and elongation	@ 77°F/25°C	5000 psi (34.5 MPa) / 10%

TECHNICAL DATA SHEET

Storage and handling

Shelf life: 12 months from date of shipment

Store AT OR BELOW 77°F/25°C

Keep containers tightly sealed.

Safety

Material Safety Data Sheet available upon request.

Warning

The information in this bulletin is believed to be reliable however, when evaluating this product, the user should consider factors such as processing and environmental conditions which may influence performance. Inasmuch as the seller is unable to control the final use of this product, our liability is limited to replacing the product or refunding the purchase price of material which is proven not to comply substantially with the data presented in this bulletin. Seller is not responsible for any commercial loss or damage arising from the use of this product. The user is responsible for determining the product's acceptability for a specific purpose and to establish safety precautions as may be required. No statements or recommendations contained in this bulletin are to be construed as inducements to infringe any relevant patent.

contact us

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